

Work Order ID 70894

Thursday, June 16, 2011 2:21:20 PM

AP



Page 1

Item ID: D3262-043

Revision ID:

Item Name: Canister Assembly

Start Date: 6/16/2011 Start Qty: 1.00



Required Date: 6/20/2011 Req'd Qty: 1.00



Accept



Setup Start



Stop



Reference:

Approvals: Process Plan: *MF*
QC: _____Date: 11-06-16 Tooling: _____ Date: _____
Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3262	E
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100	Weld per dwg A/R Aluminum rod Batch: <i>M117456</i> 0.00
-----	--



Large Fab

Memo

0.00

100 11-06-16

Large Fab

Weld canister assembly as per Dwg D3262 using DT8739 to align fittings

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
-----	--	------



QC

Quality Control

Memo

0.00

110 11-06-28 ①

120	QC5- Inspect part completeness to step on W/O	0.00
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QC

Quality Control

Memo

0.00

S ulocz

120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

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Item ID: D3262-043

Accept



Setup Start



Revision ID:

Item Name: Canister Assembly

Stop



Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
Tool ID
Tool #
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

10 BL 11-6-28.

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

1X J M 11/06/28

Memo

****Ensure to mask threads ****

START TIME:

OVEN TEMPERATURE: 320FINISH TIME: 1:451:15
320 OF
1:45

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10 BR 11-6-28

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Work Order ID 70894

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Revision ID:									
Item Name:	Canister Assembly								
Start Date:	6/16/2011	Start Qty:	1.00		Cust Item ID:				
Required Date:	6/20/2011	Req'd Qty:	1.00		Customer:				
Reference:							Run	Start	
Approvals:	Process Plan:	Date:	Tooling:	Date:			Stop		
	QC:	Date:	SPC (Y/N):	Date:					

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging	Identify as per dwg & Stock Location: Memo <i>PPP 70894</i>	0.00							<i>PC4/6/28/0</i>
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00							<i>11/16/29/JF</i>

11-06-29

W/O:		WORK ORDER CHANGES					
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Picklist Print

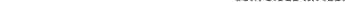
Thursday, June 16, 2011 2:21:14 PM

Page 1

Work Order ID: 70894



Parent Item: D3262-043



Parent Item Name: Canister Assembly

Start Date: 6/16/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.01.19 new issue EC verified by: DD
as per ECN10-571 DD 10.05.10 verified :EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3262-1 		Manufactured	No			100	Each	2.0000	1	1			<i>BE 1/06/27</i>
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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status

D3262-1 		Manufactured	No			100	Each	2.0000	1	1			<i>BE 1/06/27</i>
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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status

D3262-5 		Manufactured	No			100	Each	5.0000	2	2			<i>BE 1/06/27</i>
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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status

Cap 		Manufactured	No			100	Each	5.0000	2	2			<i>BE 1/06/27</i>
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Location Loc Qty Loc Code

LG002

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LG002

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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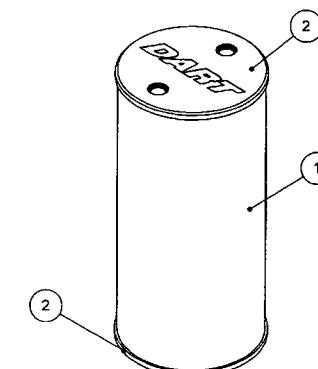
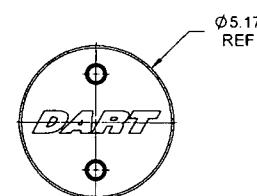
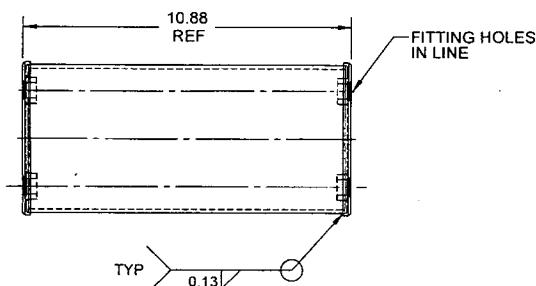
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D3262-041 CANISTER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.51 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

E	0.25 WAS 0.45 (ZN G7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5); ADD DIMENSION (ZN B1-4, D1-5, B1-5)	RF	10.05.03
D	ADD D3262-043/-5 (ZN B5-2; B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR 09-004	RF	09.12.30
C	Ø5.165 WAS Ø5.190	RF	06.08.31
B	ADD PRESSURE TESTING OPTION	MB	05.02.14
A	NEW ISSUE	RF	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3262	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FUEL PURGE CANISTER	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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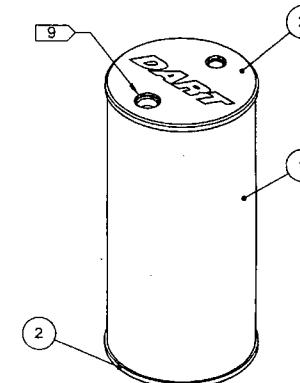
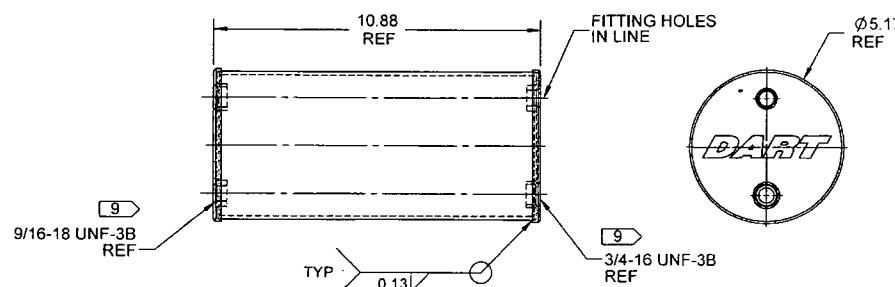
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ITEM	QTY -043	P/N	DESCRIPTION
X	D3262-043	CANISTER ASSEMBLY	
1	1	D3262-1	TUBE
2	2	D3262-5	CAP

D

D

D3262-043 CANISTER ASSEMBLY

RELEASED
R 2010-05-07
AM

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.50 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

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MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
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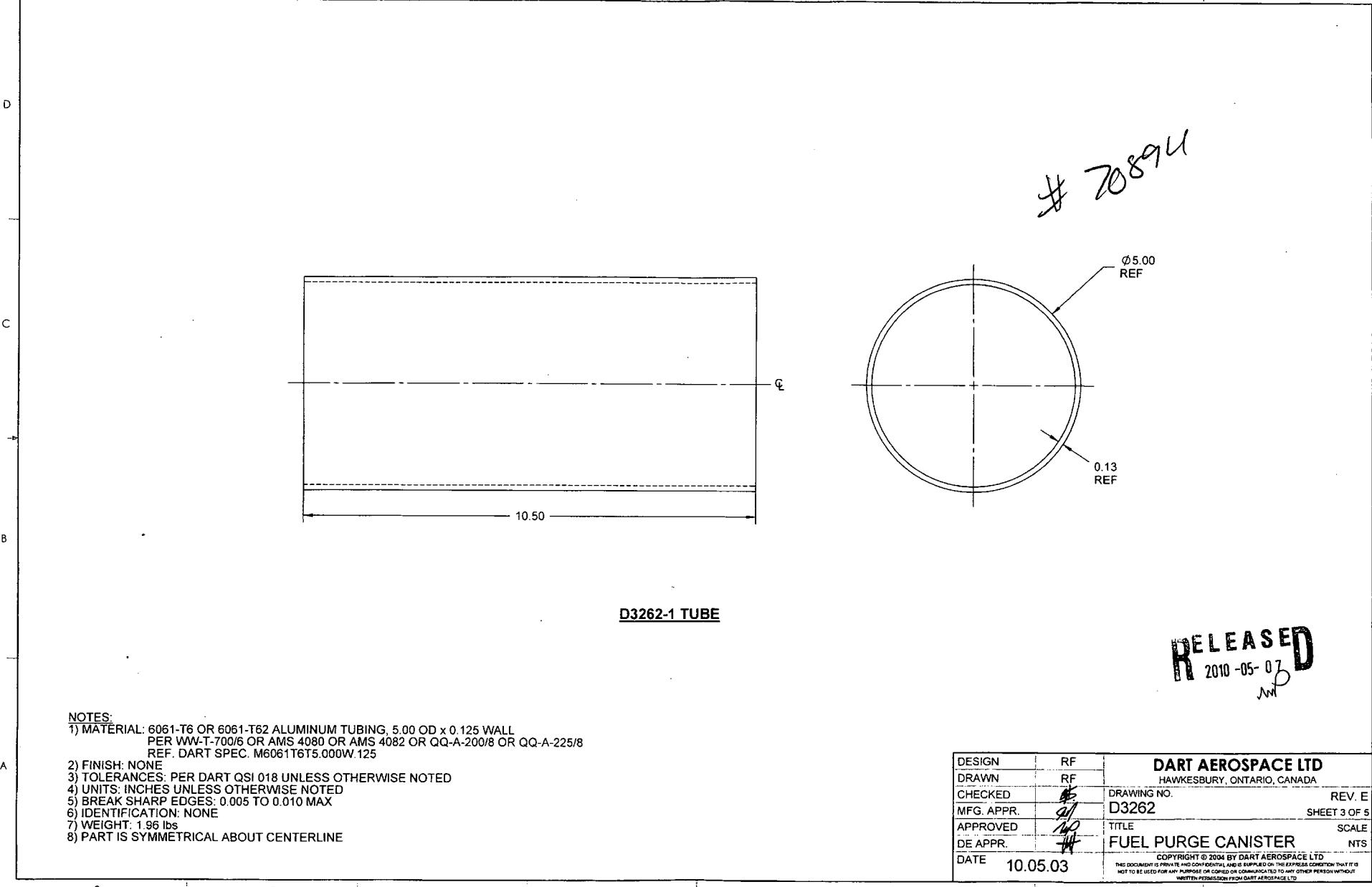
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8 7 6 5 4 3 2 1



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			D3262
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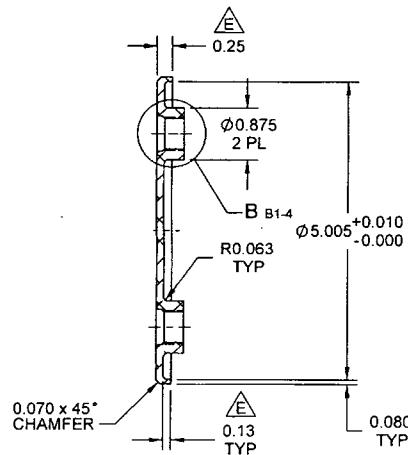
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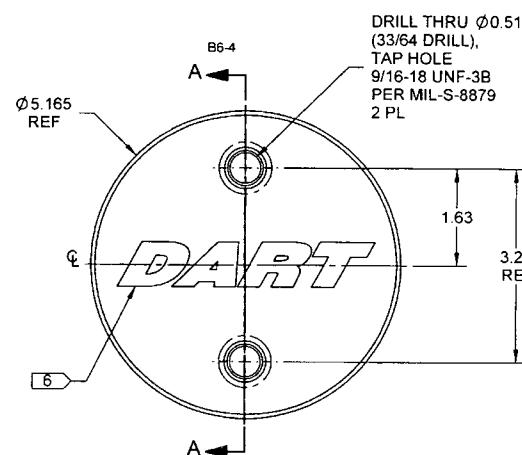
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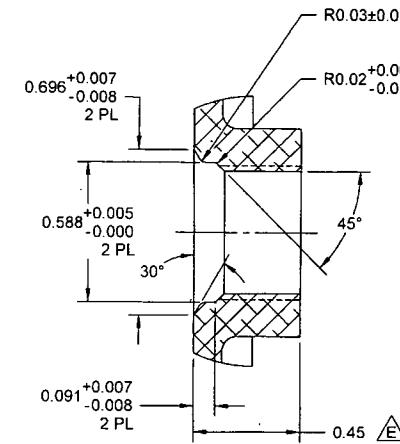
D



SECTION A-A C5-4



D3262-3 CAP

DETAIL B C7-4
SCALE 2X

RELEASED
2010-05-07
BY

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.28 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

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CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. E
APPROVED	<i>[Signature]</i>	SHEET 4 OF 5
DE APPR.	<i>[Signature]</i>	TITLE
DATE	10.05.03	SCALE
		NTS

FUEL PURGE CANISTER

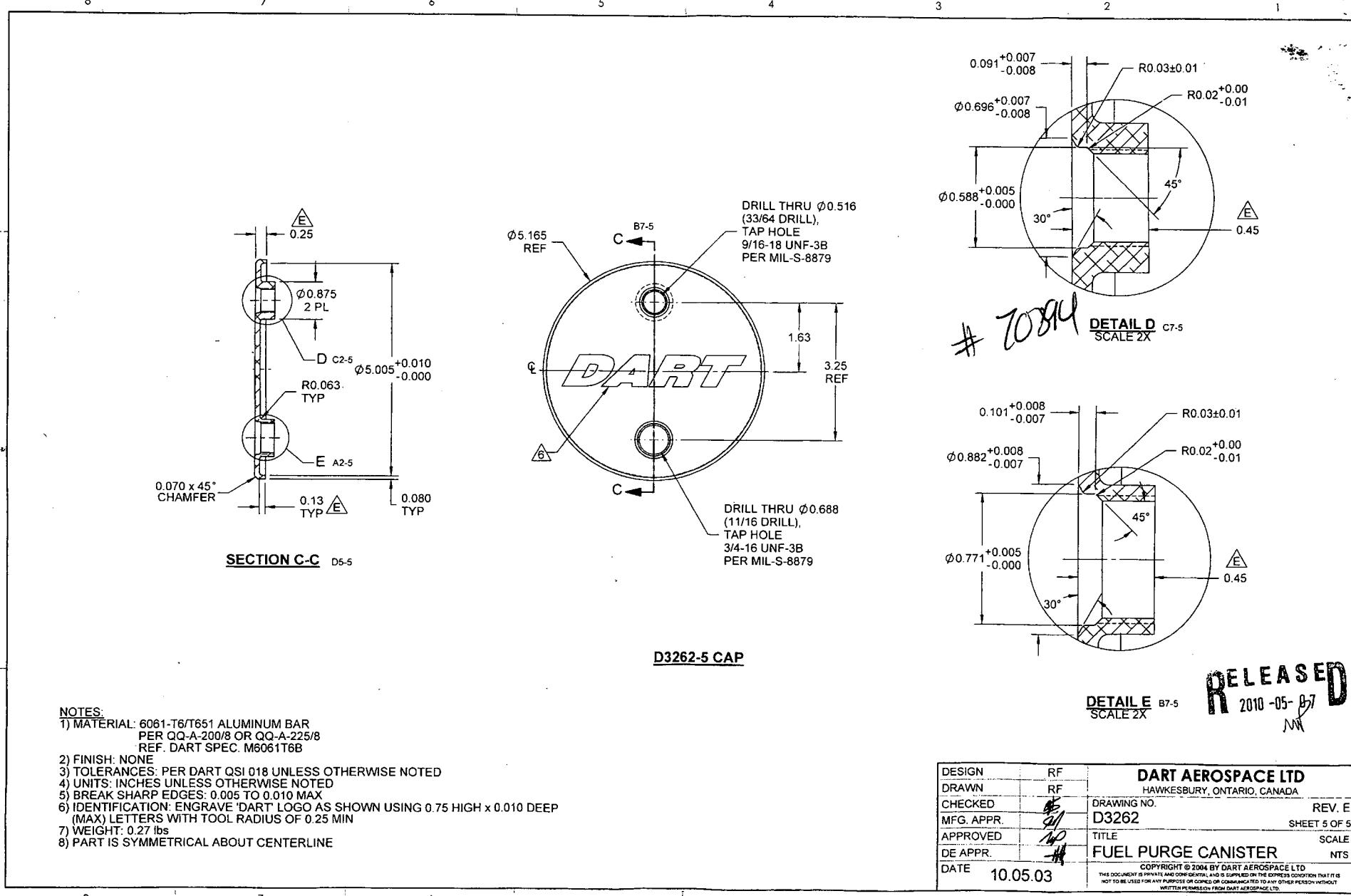
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